



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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646.3510
Job Sheet 193383



Part No: 646.3510

Job Qty: 20 pcs

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/12/19

Job Tracking No:

Due Date: 5/10/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs		5/10/19	0.00	0.79	Waterjet - Flow		02/19/06/05
120	QC 2	20 pcs		5/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/06/05
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S187754



Part: 646.3510

Job No: 193383

Serial No/Batch: S187754

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/10/19

130 QC 8	20 pcs	5/10/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Small Fab - 2 - B4B	20 pcs	5/10/19	0.03 8.23	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	20 pcs	5/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Large Fab - Basket - 2 - B4B	20 pcs	5/10/19	0.00 23.53	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	

DAS
JUN 05 2019 40
9-89

mf

el

mf

				Large Fab - 8 - B4B		
				Large Fab - 9 - B4B		
170 QC 9	20 pcs	5/10/19	0.00 0.00	QC 9 - 10		
				QC 9 - 18		
				QC 9 - 24		
				QC 9 - 43		
				QC 9 - 50		EL
				QC 9 - 9		
180 QC 5	20 pcs	5/10/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		EL
				QC 5 - 30		
				QC 5 - 40		
220 Spray Paint - 2 - B4B	20 pcs	5/10/19	0.00 0.74	Spray Paint - 1 - B4B		RD 19-6-18
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
225 Outsource	20 pcs	5/10/19		ATE003-VC 5		DAS 21 9-85
226 Packaging 2-1 - Receive - B4B	20 pcs	5/10/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B		
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		DAS 21 9-85
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 -		

				B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		DAS
				Packaging 2 - 31 - B4B		21
				Packaging 2 - 32 - B4B		9-89
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
227	QC 6	20 pcs	5/10/19	0.00	0.00	QC 6 - 9
				QC 6 - 68		
				QC 6 - 61		DAS
230	QC 14	20 pcs	5/10/19	0.00	0.00	QC 14 - 15
				QC 14 - 2		21
				QC 14 - 34		9-89
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		
				QC 14 - 40		JUN 19 2019
				QC 14 - 19		DAS
240	Packaging 3-1 - Stock - B4B	20 pcs	5/10/19	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 -		

				B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B	PC CC R103		
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B	DAG 21		
250	QC 21 - SA	20	5/10/19	0.00	0.00	QC 21 - SA - 21	9-88 JUN 19 2019
		pcs				QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op **110** - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: M/C 3 2-Deburr if necessary
 Descriptions: **120** - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH
150 - (QC5- Inspect part completeness to step on W/O)
160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.
170 - (QC9- Inspect visual per QSI004- Fusion Welds)
180 - (QC5- Inspect part completeness to step on W/O)
220 - Prime as per dwg (see note 3) Batch: 5147812
230 - (QC14- Inspect Spray Paint)
240 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
250 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5560 sf (.0278 ea)	110-Waterjet - Flow - 1	S152146
M304TR0.500W.049	304 Round Tube .500 X .049W	16.6600 ft (.833 ea)	140-Small Fab - 2 - B4B	S133773

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	266	0
140-Small Fab - 2 - B4B	M304TR0.500W.049	17	197	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780 2.720		
2	Strut	1.500Inches ± 0.030	1.530 1.470		
3	Strut	0.063Inches ± 0.010	0.073 0.053		

Plex 4/12/19 1:58 PM Dart.Hadley.Shannon



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646.3510

Job Sheet 191984



Part No: 646.3510

Job Qty: 20 ea

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs		4/15/19	0.00	0.79	Waterjet - Flow		
120	QC	20 pcs		4/15/19	0.00	0.00	QC2 Waterjet-1		
130	QC	20 pcs		4/15/19	0.00	0.00	QC8-1		
140	Small Fab	20 pcs		4/15/19	0.03	8.23	Small Fab-1		
150	QC	20 pcs		4/15/19	0.00	0.00	QC5		
160	Large Fab	20 pcs		4/15/19	0.00	23.53	Large Fab 1		
170	QC	20 pcs		4/15/19	0.00	0.00	QC9		
180	QC	20 pcs		4/15/19	0.00	0.00	QC5		
220	SprayPaint	20 pcs		4/15/19	0.00	0.74	Spray Paint		
225	Outsource	20 pcs		4/15/19			ATE003-VC	5	
230	QC	20 pcs		4/15/19	0.00	0.00	QC14		
240	Packaging	20 pcs		4/15/19	0.00	0.00	Packaging3-1		
250	QC21-SA	20 Ea		4/15/19	0.00	0.00	QC21		

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: _____ 2-Deburr if necessary

Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.

220 - Prime as per dwg (see note 3) Batch: _____

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5560 sf (.0278 ea)	110-Waterjet - Flow - 1	
M304TR0.500W.049	304 Round Tube .500 X .049W	16.6600 ft (.833 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	313	0
140-Small Fab	M304TR0.500W.049	17	86	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches $\pm$ 0.030	2.780 2.720		
2	Strut	1.500Inches $\pm$ 0.030	1.530 1.470		
3	Strut	0.063Inches $\pm$ 0.010	0.073 0.053		

Plex 3/14/19 9:23 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S187754



Part: 646.3510

Job No: 193383

Serial No/Batch: S187754

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/05/19